

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-47 Date Opened: 13 May 2015 Title: AssemblyAircraft OEM: Bell Aircraft Model: 407 Product Type: Cargo Basket Product Model: Standard Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
 Additional Work Sheets (Standard Practice)
 Drawings (See List Below)
 Parts Distribution Sheet
 Sub Component Tags
 Completed Certification
 Time Sheet (R&D)
 Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

Component Completion

Quantity Complete on This Work Order
 Quantity Incomplete on This Work Order
 Further Processing Required Before Release
 Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
 Dual Inspections Initialled

Initial or N/A

JR
JR

Certification

Form One Completed
 Serviceable (Green) Tag Completed
 In Process (Yellow) Tag Completed
 Unserviceable (Red) Tag Completed
 Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69810	3	Basket	JR
69811	3	Body	JR
69812	3	Lid	JR
69821	1	End Hoop	JR
69823	1	Lugs	JR
69827	2	Data Card	JR

Additional Documentation

Documentation of a minor change
 Non-Conformance Report Required
 Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
 Research and Development
 Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Install walkway on lid
 Install lid on basket body
 Re-tap mounting lug holes and install mount lugs
 Install handle brackets
 Install handle
 Install lid prop
 Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR
JR

Work performed by:

Print: Jason RekveSign: Jason RekveSCA: AD01Date: 13-May-15

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: Jeff ClarkeSCA: AD02Date: 13-May-15

Work Order closed by:

Print: Jason RekveSign: Jason RekveSCA: AD01Date: 13-May-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-43 47 OK	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	69810-01	1	69801-78	New	
12. Remarks Modified with Lid Step and Front End Cutout IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 13 May 2015		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

H73C

2015-47 13-May-15

CARGO BASKET ASSEMBLY - COMMON

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2015-47

Date Open: 13 May 15

OK

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

OK

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- d. Record PO of hinge and rivets on attached material tracking list.

OK

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

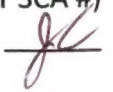
5. Install lid brace

OK

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)



6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2015-47

Material Tracking Sheet
Bell 206L / 407
Standard Basket Assembly

1 of 2

Date Opened: 13-May-15

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			69810-01	Cargo Basket Assembly		
Step 1				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		2015-38
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		69827-01	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . 4		CR3213-4-02	Cherry Rivet		
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	15056
	. . A/R		CR3213-4-02	Cherry Rivet		15031
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		69811-01	Basket Body Assembly		2015-36
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		NAS1149F0663P	Washer		
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	14091
	. 8		CR3523-5-02	Cherry Rivet		15031
	. A/R		CR3213-5-02	Cherry Rivet		15031
Step 4	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	2015-42
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		

Work Order: _____

Material Tracking Sheet

2 of 2

Bell 206L / 407

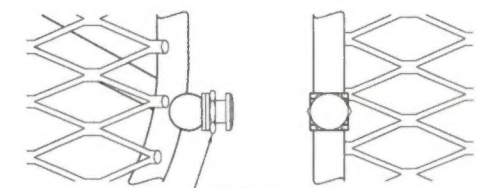
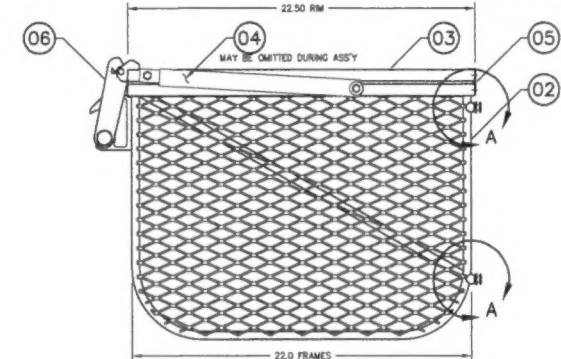
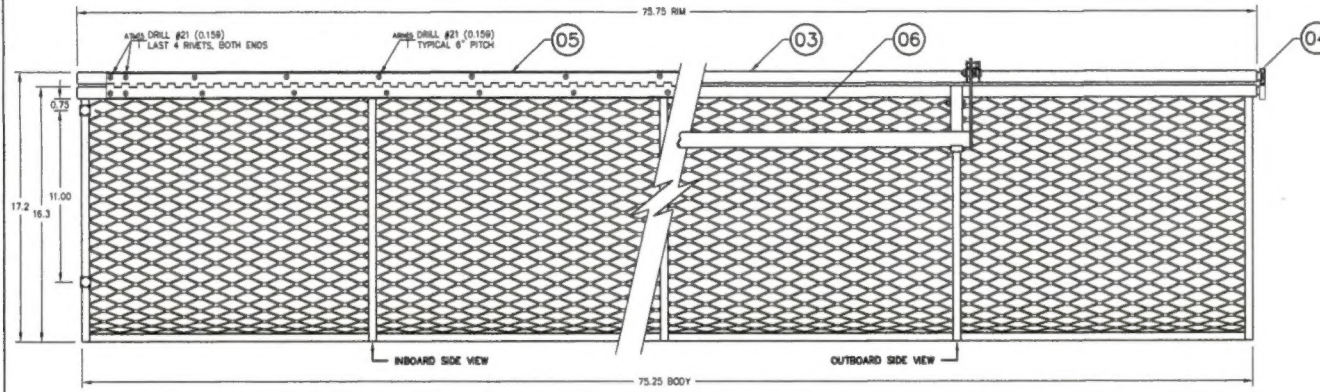
Date Opened: _____

Standard Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	. . 1		84261-01	Handle Assembly		15018
	. . 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	. . 2		36275-01	Bushing	Brass, 5/16" Dia	
	. . 2		AN3-12A	Bolt		
	. . 4		NAS1149F0363P	Washer		
	. . 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2014-63
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				Inspection	None	

2015-47

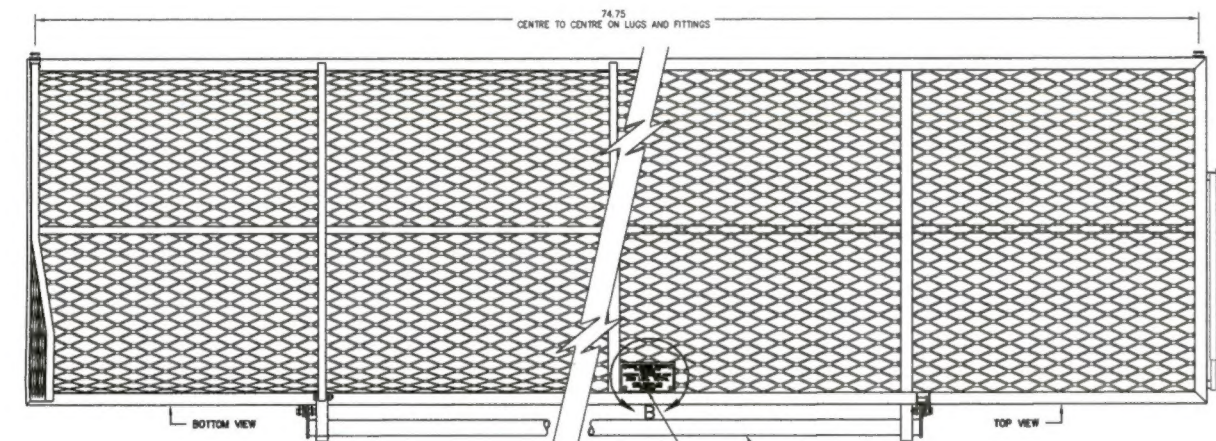
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED LUGS	BJC	08/11/2008
2	PLACARD CHANGED, AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	28/06/2007
3	HINGE RIVETS CHANGED, HANDLE DETAILS CHANGED, PLACARD CHANGED	BJC	14/10/2011



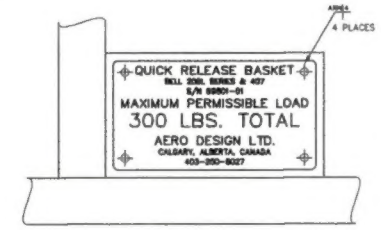
DETAIL A

SCALE 1 : 1
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
TYPICAL FRONT AND REAR

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS
AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

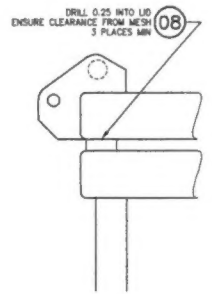


01 CARGO BASKET ASSEMBLY

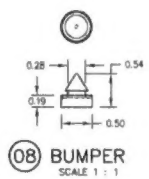


DETAIL B

SCALE 1 : 1
LOOKING AT PLACARD BRACKET



BUMPER INSTALLATION
SCALE 1 : 1

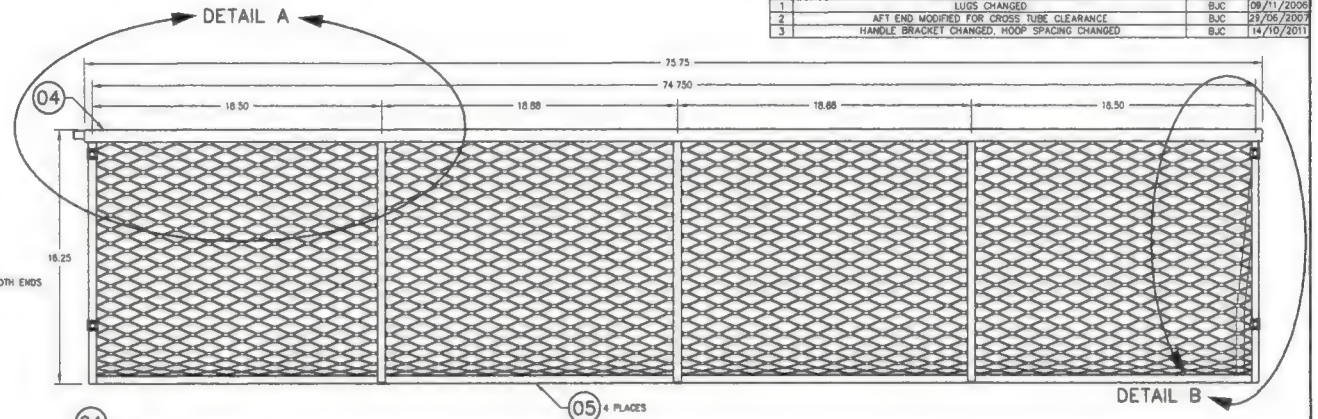
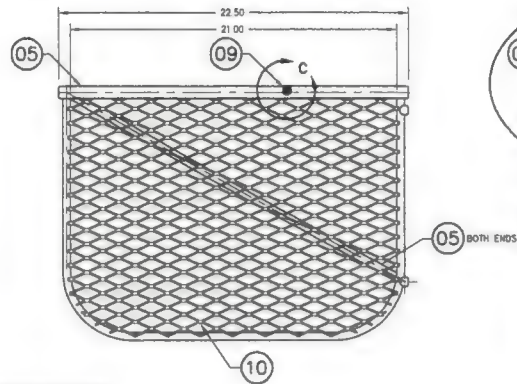


08 BUMPER
SCALE 1 : 1

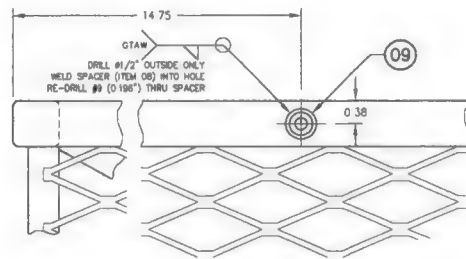
A/R	AN960-516	WASHER				
4	40088-14	FITTING	ANCR4			
4	CR3213-4-02	CHERRY RIVET				
8	CR3523-5-02	CHERRY RIVET				
A/R	CR3213-5-02	CHERRY RIVET				
3	49205-14	08 BUMPER	ARGUS INDUSTRIES			
1	69827-01	07 PLACARD				
1	84255-01	06 HANDLE BAR INSTALLATION				
1	MS20001P4	05 PLANO HINGE			6 FEET LONG	
1	36280-01	04 BRACE ASSEMBLY				
1	69812-01	03 LID ASSEMBLY				
1	69811-01	02 BASKET BODY ASSEMBLY				
1	69810-01	01 CARGO BASKET ASSEMBLY				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
				LIST OF MATERIALS		

BASIC CODE REF. MAS 323	DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	DASH NO. FOR LENGTH	APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON	DATE 11 APR 2006	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA. TEE 697 tel: (403) 590-8087 fax: (403) 590-8088 aerodesign@caluglenet.net
C=COUNTERSUNK D=DIMPLE DGT=4 OF SHEETS TO BE DIMPLED	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	INSTALL NEW RIVET REMOVE/REPLACE RIVET EXISTING RIVET	SCALE 1 : 4 SHEET 1 OF 1	DWG. NO. A1	REV. 69810 3

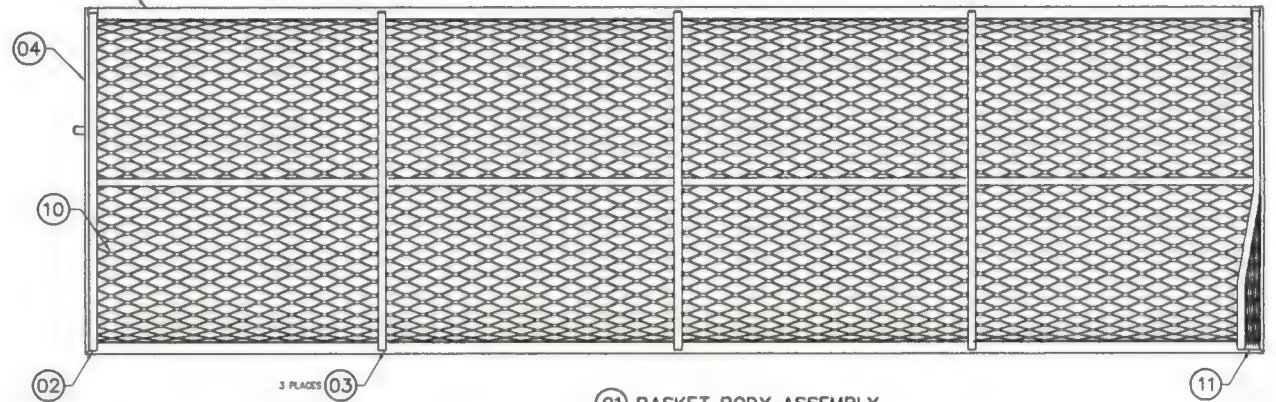
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LUGS CHANGED	BJC	09/11/2006
2	AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	23/06/2007
3	HANDLE BRACKET CHANGED, HOOP SPACING CHANGED	BJC	14/10/2011



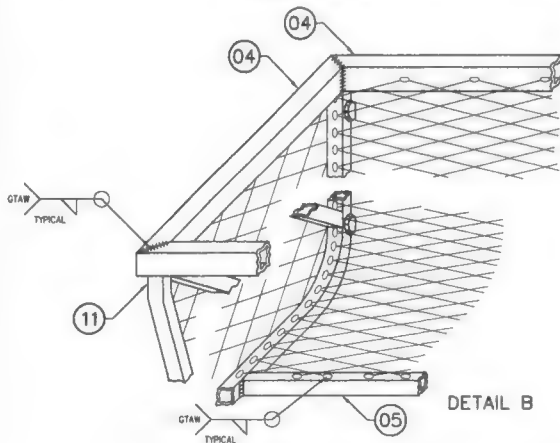
- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
 3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
 4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY



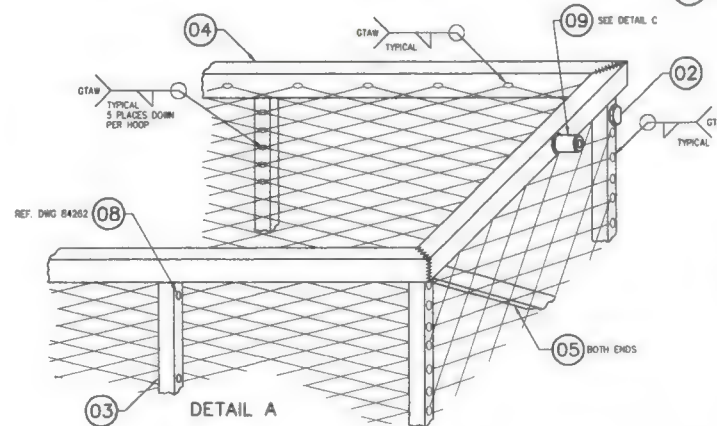
DETAIL C
SCALE 1:1
VIEW LOOKING AT FRONT RIM OF BASKET



01 BASKET BODY ASSEMBLY



DETAIL B

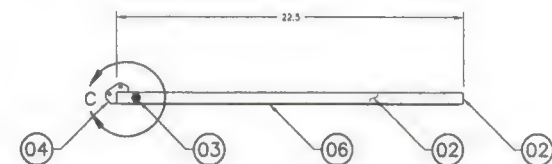
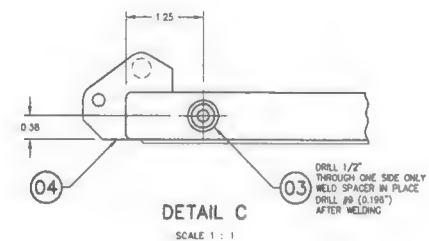
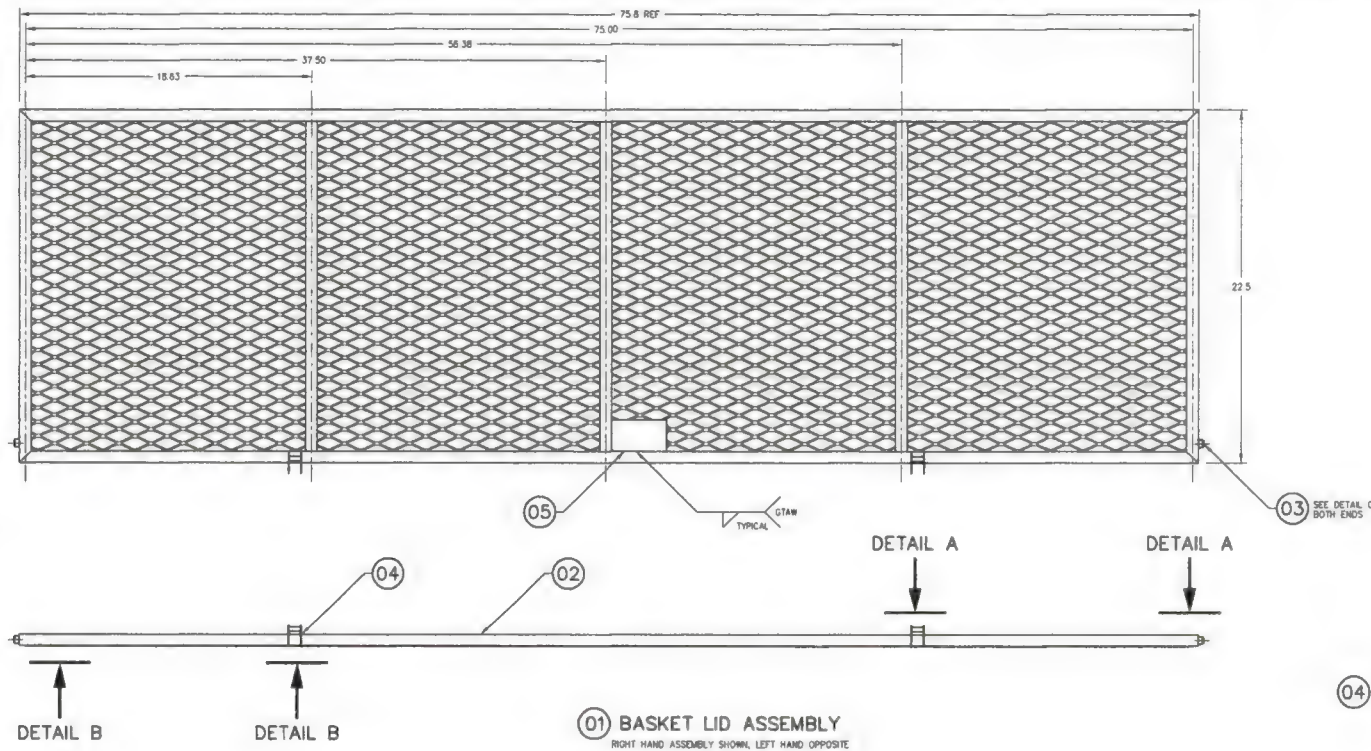


DETAIL A

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	69822-01	11	AFT END HOOP	STEEL	COMMERCIAL	
A/R	3/4-16F	10	MESH			
1	49215-01	09	SPACER			
1	84262-01	08	HANDLE BRACKET ASSEMBLY			
		07				
		06				
A/R		05	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 SOR TUBE
A/R		04	TUBE	4130 STEEL COND N	MIL-T-6736	0.75 X 0.035 SOR TUBE
3	49210-02	03	HOOP			
1	69821-01	02	FORWARD END HOOP			
1	69811-01	01	BASKET BODY ASSEMBLY			


APPROVALS		DATE	
DRAWN	JEFF CLARKE	11 APR 2006	
CHECKED	E BURGON		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:			
DECIMALS		ANGLES	
X.XXX ±0.010		±1/2°	
X.XX ±0.03			
X.X ±0.1			
AERO DESIGN LTD.			
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 280M			
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6K7			
Tel: (403) 266-8001 Fax: (403) 266-8053 aerd@design.ca aerd@design.net			
BELL 206L 407			
QUICK RELEASE CARGO BASKET			
BASKET BODY ASSEMBLY			
SCALE 1:4		DWG SIZE	DWG NO
SHEET 1 OF 1		A1	69811
			3

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL RELEASE		
1	CHANGED LOCATIONS OF SUPPORTS	RR	20 FEB 08
2	CHANGED HANDLE BRACKETS, AND LEFT HAND CONFIGURATION	BJC	28 JAN 10
3	CHANGED LOCATION OF SUPPORTS, REMOVE SIDED CONFIGURATIONS	BJC	15 SEPT 11



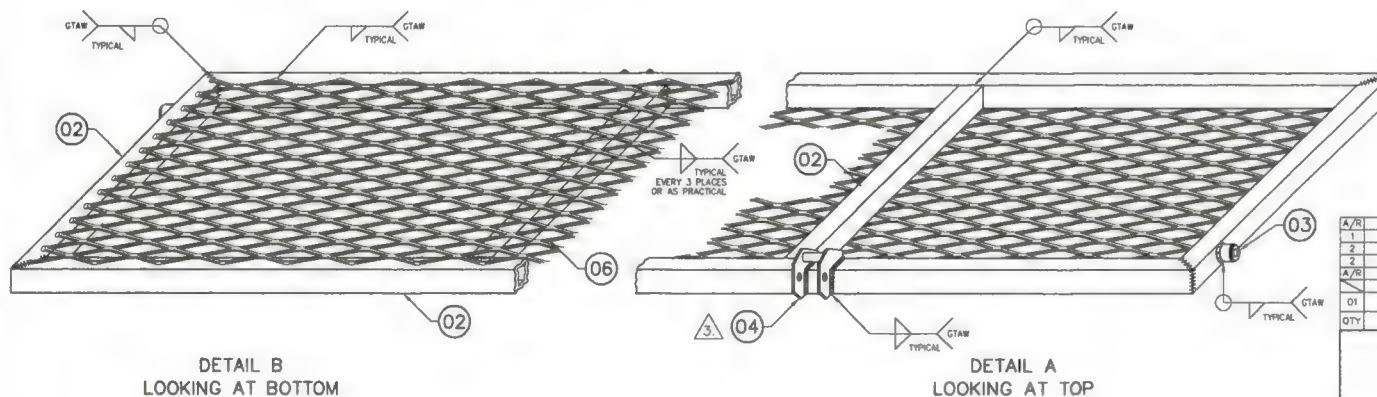
NOTES:

- 1 REMOVE ALL BURRS AND BREAK SHARP EDGES
- 2 WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C
- 3 WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.

 INSTALL ITEM 8 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD DRAWING 84262

2 PLACES.

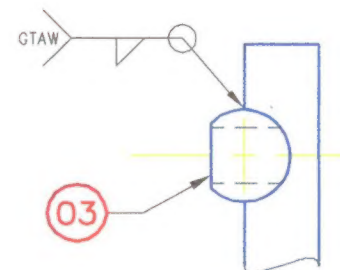
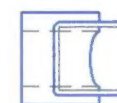
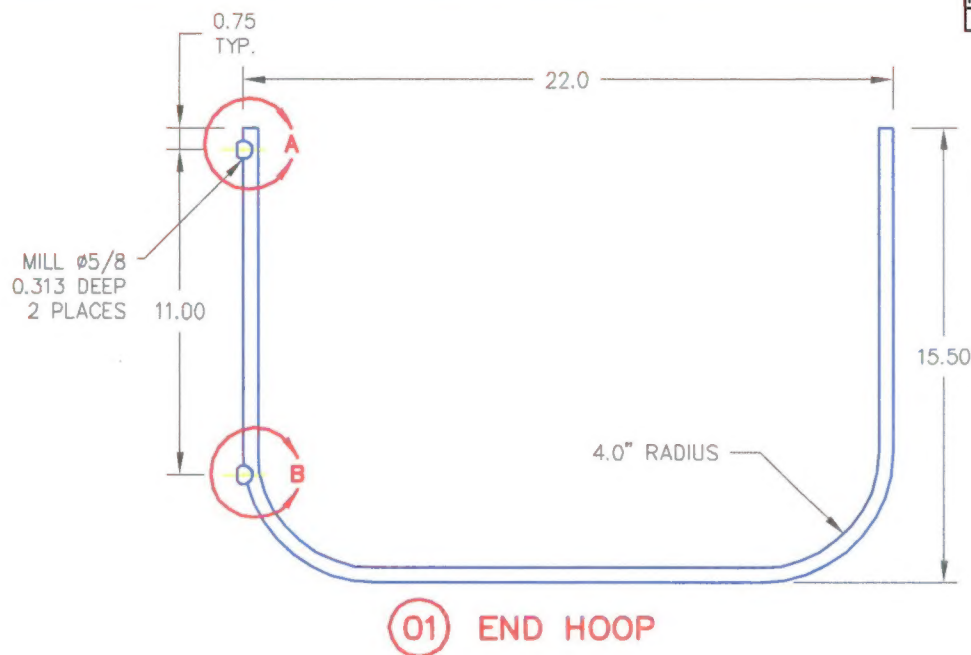
- 4 WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- 5 THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.



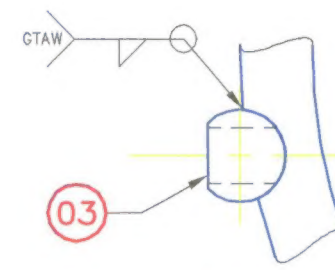
A/R	3/2-18"	06	UPH		MILD STEEL	COMMERCIAL	
1	36204-10	03	PLACARD BRACKET				
2	84202	04	UPPER HANDLE BRACKET ASSY				
2	49216-01	03	SPACER				
A/R	-	02	TUBE		4130 STEEL, COND N	MIL-T-6736	0.75 X 0.035 SQ. TUBE
01	69812-01	03	BASKET LID ASSEMBLY				
QTY	PART NO.	ITEM	DESCRIPTION		MATERIAL	MATERIAL SPEC	STOCK SIZE
				LIST OF MATERIALS			

APPROVALS DRAWN: JEFF CLARKE 11 APR 2005 CHECKED: E. BURGON UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE DECIMALS ANGLES .XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 8013 - 99TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6B7 tel: (403) 250-3087 fax: (403) 250-3333 aerodesign@aerocan.net	
QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY				SCALE 1 : 4 SHEET 1 OF 1 DWG SIZE A1 DWG NO 69812 REV 3	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVED LUG (ITEM 2), BOTH LUGS NOW ITEM 3	BJC	09/11/2006



DETAIL A
SCALE 1 : 1



DETAIL B
SCALE 1 : 1

NOTES

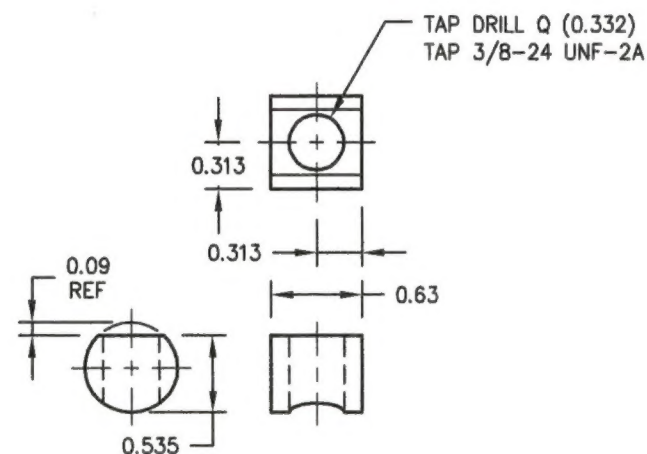
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL 3/32 VENT HOLE IN BOTTOM OF HOOP FOR VENTING OF WELD GASES
3. WELDING OF STAINLESS STEEL LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS 5680 (347 STAINLESS STEEL) OR EQUIVALENT.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	69823-02	03	LUG	304 STAINLESS STEEL	ASTM A476	5/8 DIA ROD
	--	02	--			
	69821-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE

LIST OF MATERIALS

NOTICE THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON	DATE 10 APR 2006	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 206L, 407 QUICK RELEASE CARGO BASKET BASKET COMPONENTS - END HOOP			
	SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.		
	SHEET 1 OF 1	LGL	69821	1		

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVE LUG (ITEM 1)	BJC	27/02/2007



02 LUG

69823-02	02	LUG	1018 MILD STEEL	ISI 1010/1020	5/8 DIA ROD
	01				
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS				

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	DRAWN: JEFF CLARKE		10 APR 2006					
	CHECKED: E. BURGOIN				BELL 206L, 407 QUICK RELEASE CARGO BASKET BASKET COMPONENTS - LUGS			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1							
NOTICE	SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
	SHEET 1 OF 1		LGL		69823		1	

NOTICE

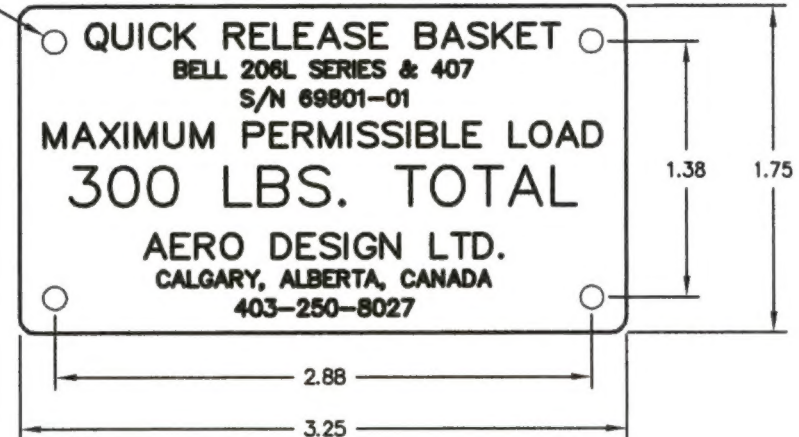
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED TO ENGRAVED ALUMINUM	BJC	19 JUNE 2007
2	INCREASED LOAD	BJC	26 OCT 2011

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"BELL 206L SERIES & 407" - 0.080 HIGH
"S/N 69801-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"300 LBS. TOTAL" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

1	69827-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net	
			DRAWN: JEFF CLARKE	24 APR 2006		
			CHECKED: E. BURGOIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206L SERIES AND 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1		DWG. SIZE	DWG. NO.
			SHEET 1 OF 1		A4	69827
						2

Aero Design

Parts Distribution Sheet

Description: Basket Assembly Kit

WO# 2015-47

[illegible]